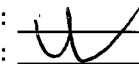
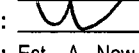


Date: Thursday, 28/06/2007 10:15:19 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : A119 BUBBLE WINDOW ASSY
Job Number : 33245	
Estimate Number : 12914	
P.O. Number : N/A	Part Number : D119755014
This Issue : 28/06/2007 S.O. No. : N/A	Drawing Number : D3624
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : THERMOFORMING	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : 	Due Date : 29/06/2007 Qty: 1 Um: Each
Checked & Approved By : 	
Comment : Est A New Issue 6/28/2007 DL	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP 119755014 CHG 1

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	33245A	A119 BUBBLE WINDOW
-----	--------	--------------------



Comment: Sub-Component A119 BUBBLE WINDOW

4.0	D2126	Seal
-----	-------	------



Comment: Qty.: 7.4372 f(s)/Unit Total : 7.4372 f(s) (50 f)

Seal

Batch# 632619

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
-----	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 07/06/29
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 28/06/2007 10:15:19 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 BUBBLE WINDOW ASSY

Job Number: 33245

Part Number: D119755014

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D119755014

Location:

PPP Rev:

Post

E 11/12/29 (1)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(1) 07/06/29

Job Completion



U 07-06-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

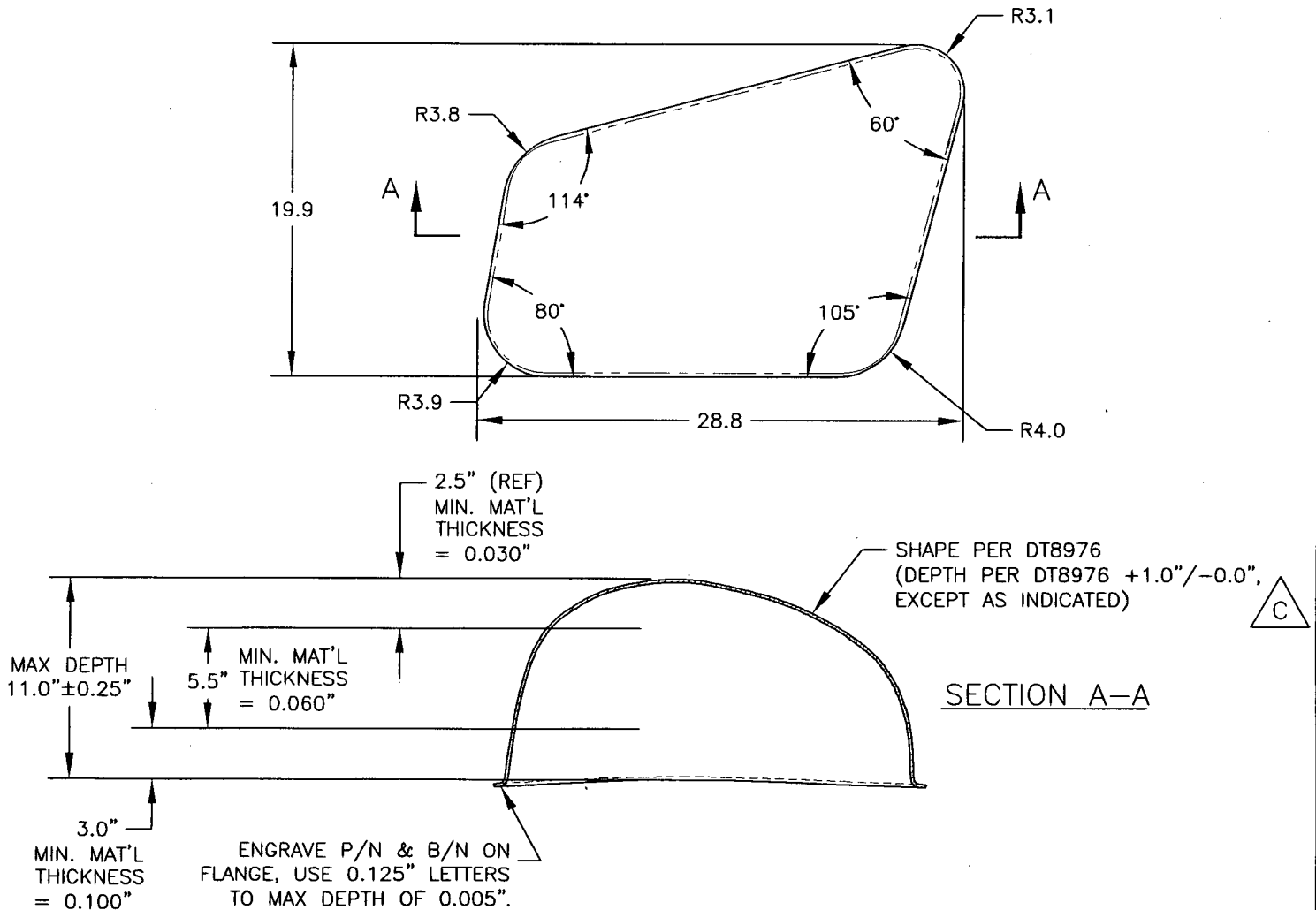
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3624	REV. C SHEET 1 OF 1
DATE 07.06.27	TITLE BUBBLE WINDOW (A119)		SCALE 1:10
A	07.05.14	NEW ISSUE	
B	07.05.24	11.0" DEPTH WAS 12.0"	
C	07.06.27	ADD TOOL TO CONTROL BUBBLE SHAPE	

RELEASED
07.06.28 *#***D3624-2 BUBBLE WINDOW**

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC OR PLEXIGLAS "G" CAST ACRYLIC, 0.177" THICK (REF DART SPEC. M-ACRYLIC-S.177)
- 2) FORM PER DT8953
FORMING PROCESS:
 - (a) DRAPE MAT'L OVER DT8953 MOLD
 - (b) HEAT TO 286°F
 - (c) VACUUM TO SPECIFIED HEIGHT
 - (d) LEAVE FOR AT 2 MINUTES TO COOL
 - (e) TRIM WINDOW PER DT8954
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **33245A**

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Date: Thursday, 28/06/2007 10:15:20 AM
User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	A119 BUBBLE WINDOW
Job Number :	33245A	Part Number :	D36242
Estimate Number :	12911	Drawing Number :	D3624
P.O. Number :		Project Number :	
This Issue :	28/06/2007	S.O. No. :	
Prsht Rev. :	NC	Drawing Revision :	REV. <i>X</i> Rev. C <i>07.06.28</i>
First Issue :	//	Material :	
Previous Run :		Due Date :	29/06/2007
Written By :	<i>W</i>	Qty:	1 Um: Each
Checked & Approved By :			
Comment :	Est. A Thermoform in house 6/27/2007 DL		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	MACRYLICS177	0.177" PLEXIGLAS G CLEAR CAST ACRYLIC SH
-----	--------------	--



Comment: Qty.: 10.0000 sf(s)/Unit Total : 10.0000 sf(s)
0.177" PLEXIGLAS G CLEAR CAST ACRYLIC SH

Mt. 10100655

Batch - M 104325

2.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

07.06.28 *Sh*

Trim Blank for Thermoformer

3.0	THERMOFORMING	THERMOFORMING MACHINE
-----	---------------	-----------------------



Comment: THERMOFORMING MACHINE

Sh 07.06.28

Thermoform as per Dwg. D3624 Rev. *C* and Folio FTA 004 Rev. A

07.06.28 *DL*

Dwg. Rev. *E* *Sh*

Folio Rev. *D*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check depth of bubble to ensure conformity to drawing tolerances.

07.06.28 *DL*
SHAPE IS ACCEPTABLE
07.06.28
DL TO VERIFY DIMENSIONS.

Date: Thursday, 28/06/2007 10:15:20 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 BUBBLE WINDOW

Job Number: 33245A

Part Number: D36242

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Mark out with template and trim to finish dimensions.

07.06.28 196

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

07.06.28 (V)

07.06.28 196

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

N/A 2

8.0

HAND FINISHING2

HAND FINISHING RESOURCE #2



Comment: HAND FINISHING RESOURCE #2

Polish out mould marks.

Add cut out as per template provided by customer.

Etch Part# & Batch #

07.06.28 196
07.07.03 196

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/03 07.06.28 (V)

inspected the cut out performed on 07/07/03 by DL

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

07/7/03 (V) 33245

11.0

QC21

FINAL INSPECTION/W/O RELEASE

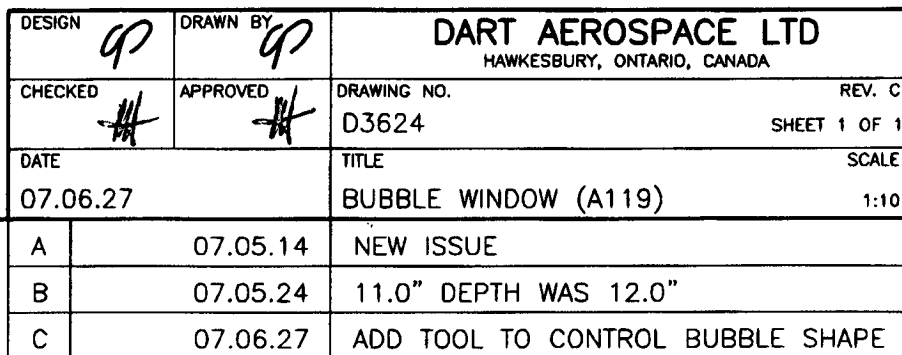


Comment: FINAL INSPECTION/W/O RELEASE

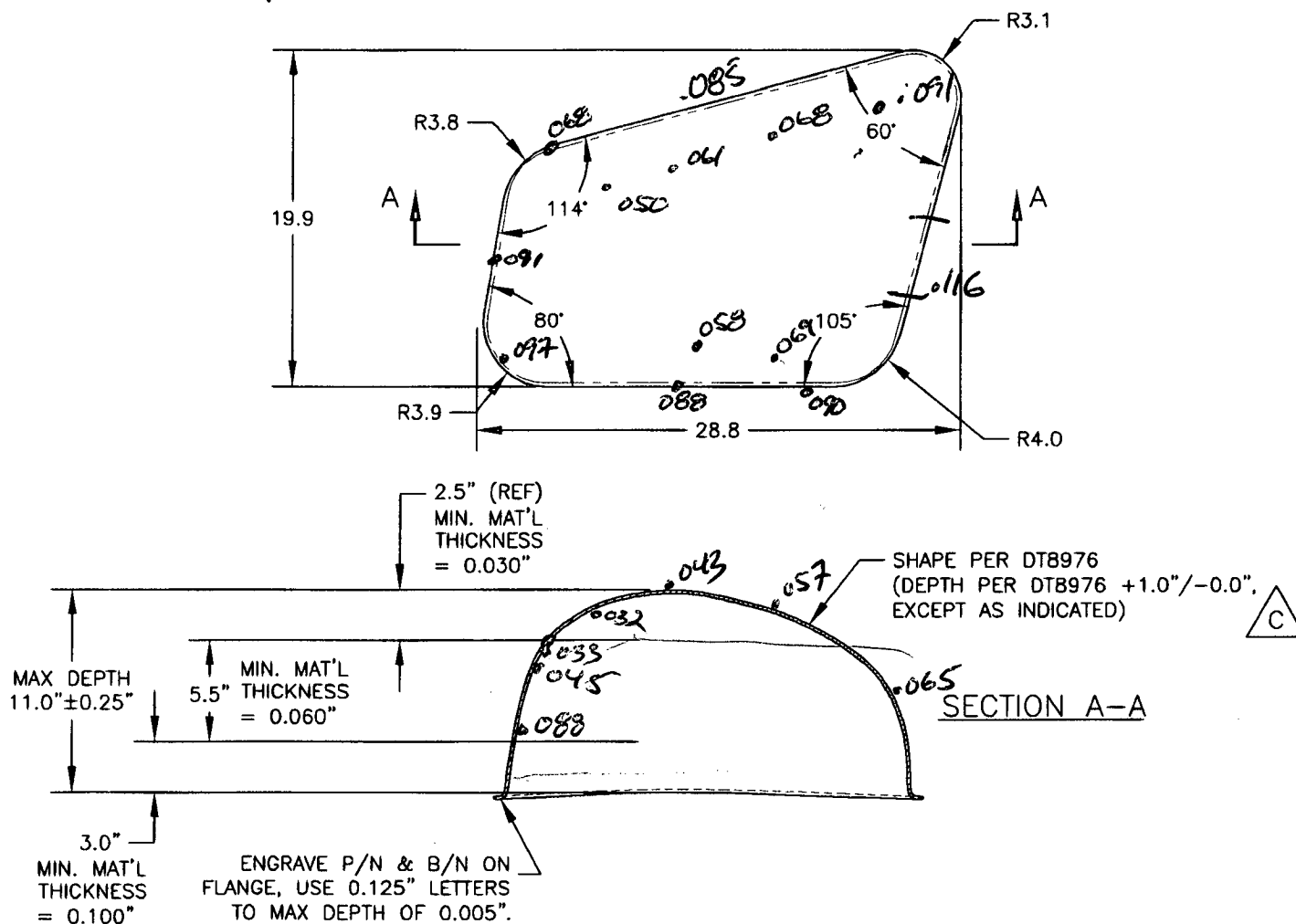
Job Completion



07.06.29



RELEASED
07-06-28



1) MATERIAL: POLYCAST II CLEAR ACRYLIC OR PLEXIGLAS "G" CAST ACRYLIC, 0.177" THICK
(REF DART SPEC. M-ACRYLIC-S.177)

2) FORM PER DT8953

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3) ALL DIMENSIONS ARE IN INCHES

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